



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572
Job Sheet 174052



Part No: D2572

Job Qty: 15 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: **SOLD**

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	15 Ea	3/28/18		0.00	0.00	Start Up Machining		SBL 18/5/23
100	CNC Vertical Machining	15 pcs	3/29/18		0.62	24.19	HAAS 1		SBL 18/06/01
110	Mill Conv	15 pcs	3/29/18		0.00	2.50	Mill Conv 1		SBL 18/06/01
120	QC	15 pcs	3/29/18		0.00	0.00	QC2		SBL 18/06/01
130	QC	15 pcs	3/29/18		0.00	0.00	QC8		Re 18-06-02
140	HandFinish	15 pcs	3/29/18		0.00	0.62	HandFinish1		SA 18-06-04
150	Powdercoat	15 pcs	3/30/18		0.00	0.57	Powdercoat1		BLOAB-6-5
160	QC	15 pcs	3/30/18		0.00	0.00	QC3		13 JUN 05 2018
170	Packaging	15 pcs	3/30/18		0.00	0.00	Packaging3	ST 397 80	JUN 06 2018
180	QC21-SA	15 Ea	3/30/18		0.00	0.00	QC21		21 JUN 06 2018

Part Op 100 - Program Batch No. 502286 Double check by: JMK 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

110 - Machine keyway as per dwg D2571 & D2572

150 - START TIME: 9:25 FINISH TIME: 9:55 ON T: 320° M: 138839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	15 Ea (1 ea)	90-Start up Operation	

5069067 → 5072783

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	15	29	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle



Container No: S072786



Part: D2572

Job No: 174052

Serial No/Batch: S072786

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/18

4	Saddle, Fwd Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020	0.043

DART AEROSPACE LTD	Work Order: 174052	
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.004	8.008		
F	0.490	0.510		.500	.502	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.566	.567	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.130	.130	.130		
Q	0.115	0.135		.130	.125	.125	.125		
R	0.240	0.260		.242	.251	.252	.252		
S	0.115	0.135		.130	.123	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.234	.234	.235		
W	0.115	0.135		.130	.135	.135	.132		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.623	.623	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.244	.251	.251	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.130	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.255		
AH	0.240	0.260		.244	.250	.251	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	57
Date:	9-89 18/05/27

Audited by:	B.E
Date:	18-06-07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 174052
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.007	8.010	8.008	8.008		
F	0.490	0.510		0.502	0.506	0.504	0.504		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.132	0.130	0.130	0.133		
Q	0.115	0.135		0.126	0.126	0.125	0.126		
R	0.240	0.260		0.253	0.253	0.251	0.252		
S	0.115	0.135		0.126	0.126	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		0.235	0.233	0.233	0.233		
W	0.115	0.135		0.126	0.124	0.130	0.133		
X	0.307	0.312		0.310	0.312	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.622	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.250	0.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.135		
AG	0.240	0.280		0.255	0.255	0.255	0.260		
AH	0.240	0.260		0.249	0.250	0.250	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

BAS

Measured by:	57
Date:	9-89

Audited by:	K.e
Date:	18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 174 052
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		0.443	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.001		
F	0.490	0.510		0.500	0.501	0.500	0.500		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.134	0.133	0.130		
Q	0.115	0.135		0.126	0.127	0.126	0.126		
R	0.240	0.260		0.252	0.253	0.252	0.253		
S	0.115	0.135		0.125	0.125	0.126	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		0.233	0.237	0.236	0.236		
W	0.115	0.135		0.130	0.130	0.130	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.368	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.624	0.623		
AC	0.053	0.073		0.063	0.060	0.063	0.063		
AD	0.240	0.260		0.250	0.255	0.251	0.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.255	0.255	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.030		
Accept/Reject									

Measured by:	57
Date:	9-89

Audited by:	K.A.
Date:	18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order: 174052
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#13	#14	#15	4		
A	0.438	0.443		.438	.438	.438			
B	1.745	1.755		1.750	1.750	1.750			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.750	1.750	1.750			
E	7.990	8.010		8.008	8.009	8.009			
F	0.490	0.510		.498	.501	.501			
G	0.257	0.262		.257	.257	.257			
H	0.375	0.380		.375	.375	.375			
I	0.490	0.510		.498	.499	.499			
J	1.174	1.184		1.179	1.179	1.179			
K	0.558	0.578		.567	.567	.568			
L	1.174	1.184		1.179	1.179	1.179			
M	1.490	1.500		1.495	1.495	1.495			
N	2.495	2.505		2.500	2.500	2.500			
O	3.869	3.879		3.874	3.874	3.874			
P	0.115	0.135		.132	.133	.131			
Q	0.115	0.135		.127	.126	.127			
R	0.240	0.260		.252	.252	.252			
S	0.115	0.135		.127	.122	.123			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.960	2.962	2.962			
V	0.230	0.250		.236	.235	.236			
W	0.115	0.135		.130	.124	.130			
X	0.307	0.312		.311	.311	.311			
Y	0.760	0.765		.760	.760	.760			
Z	0.352	0.372		.363	.355	.363			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.623	.623	.623			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.251	.251	.251			
AE	1.375	1.395		1.385	1.385	1.385			
AF	0.115	0.135		.130	.130	.133			
AG	0.240	0.280		.255	.255	.260			
AH	0.240	0.260		.248	.245	.246			
AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

Measured by: 57
Date: 9-89

Audited by: H.F.
Date: 18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	